



Dart Aerospace Ltd.
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Canada

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Urgent

D4753-1

Job Sheet 174779



Part No: D4753-1

Job Qty: 70 ea

Part Name: Doubler



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/21/18

Job Tracking No:

Due Date: 3/26/18

Created By: Jason Leroux

Type: Stock

Description:

Note: DWG REV A IPP REV:A NEW ISSUE 13-02-21 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard	Workcenter/Supplier		Sign-off
					Setup Run hrs Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	70 Ea	3/23/18	3/23/18	0.00 0.00	Start Up Waterjet		<i>18/03/21</i>
100	Waterjet	70 pcs	3/24/18	3/24/18	0.00 2.10	Waterjet1		<i>18/03/21</i>
110	QC	70 pcs	3/24/18	3/24/18	0.00 0.00	QC2 Waterjet-1		<i>18/03/21</i>
120	CNC Vertical Machining	70 pcs	3/24/18	3/24/18	0.02 5.04	HAAS1-5		<i>18-04-13</i>
140	QC	70 pcs	3/24/18	3/24/18	0.00 0.00	QC8		<i>18/04/14</i>
150	Small Fab	70 pcs	3/24/18	3/24/18	0.00 0.83	Small Fab-7		<i>18-04-13</i>
160	QC	70 pcs	3/24/18	3/24/18	0.00 0.00	QC5		<i>18-04-17</i>
170	HandFinish	70 pcs	3/26/18	3/26/18	0.00 0.58	HandFinish1		<i>18-04-17</i>
180	QC	70 pcs	3/26/18	3/26/18	0.00 0.00	QC7-4		<i>18-04-17</i>
190	Packaging	70 pcs	3/26/18	3/26/18	0.00 0.00	Packaging3-2		<i>18-04-17</i>
200	QC21-SA	70 Ea	3/26/18	3/26/18	0.00 0.00	QC21		<i>18-04-17</i>

Part Op 100 - 1-Cut as per Dwg D4753 Dwg Rev: *A* Prog Rev: *A* ***.758" DIA HOLE TO BE OPENED TO FIN

Descriptions: SIZE BY SKID DEPARTMENT UPON INSTALLATION** 3- Deburr if necessary

120 - Machine as per Folio FB163 and Dwg D3506 FOLIO REV: _____ DWG REV: _____ ***.758" DIA HOLE TO BE OPENED TO FIN SIZE BY SKID DEPARTMENT UPON INSTALLATION**

150 - C'sink as per Dwg D4753 (On Flat side)

190 - LOCATION : LG001

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.125	6061-T6 .125 Sheet	.9660 sf (.0138 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6S.125	1	150	0

Date: 03/21/18

Inspector:
Revision:

Part: D4753-1
Job No: 174779
Serial No/Batch: S053532



Container No: S053532

CART
AEROSPACE

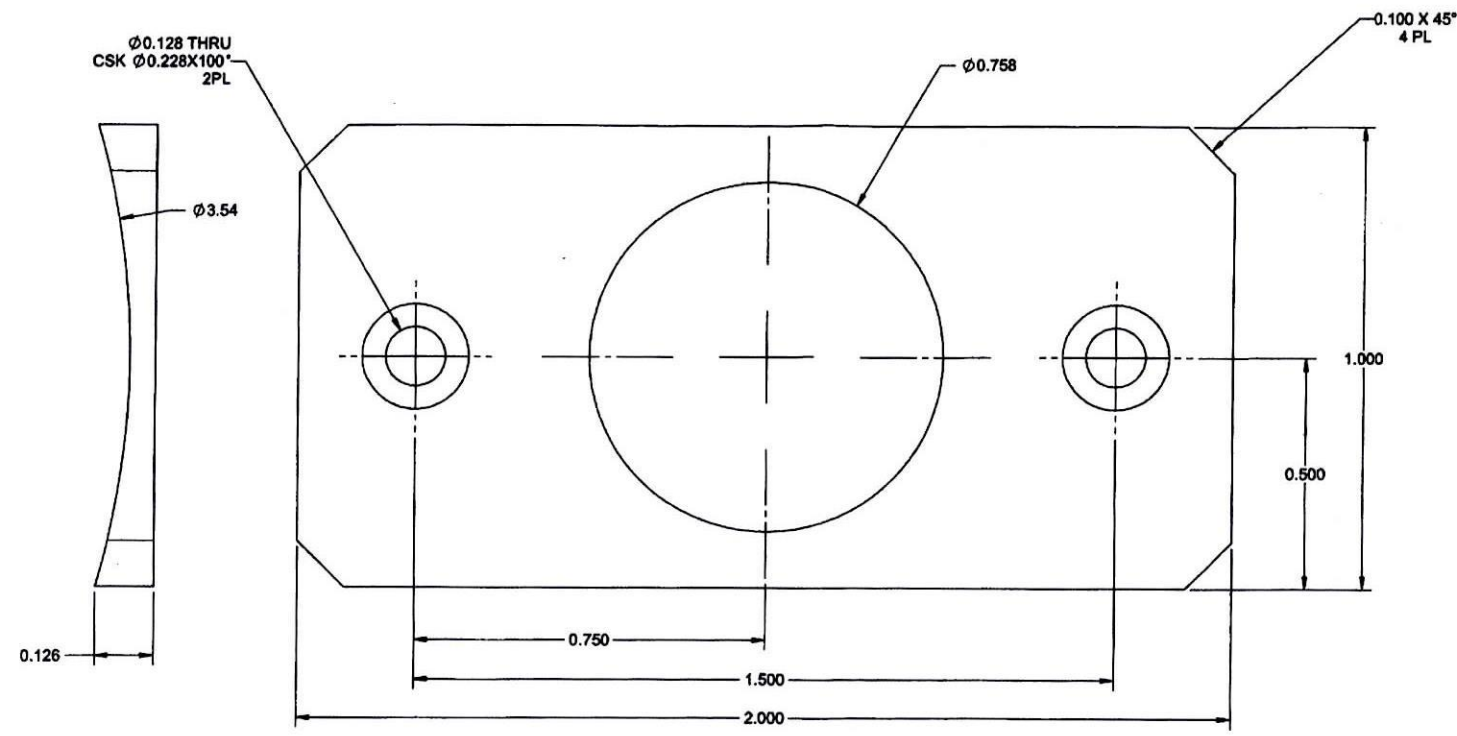
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CANADA
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Email: sales@dwaters.com
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Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Doubler	0.128Inches + 0.005 - 0.001	0.133 0.127	Diameter	
2	Doubler	0.500Inches ± 0.010	0.510 0.490		
3	Doubler	1.000Inches ± 0.010	1.010 0.990		
4	Doubler	0.750Inches ± 0.010	0.760 0.740		
5	Doubler	1.500Inches ± 0.010	1.510 1.490		
6	Doubler	2.000Inches ± 0.010	2.010 1.990		
7	Doubler	0.126Inches ± 0.010	0.136 0.116		
8	Doubler	3.540Inches + 0.012 - 0.001	3.552 3.539	Diameter	
9	Doubler	0.126Inches ± 0.010	0.136 0.116		

Plex 3/21/18 12:48 PM dart.leroux.jason

8 7 6 5 4 3 2 1

D
C
B
A



D4753-1 DOUBLER

- NOTES:**
 1) MATERIAL: 6061-T6/T651 ALUMINUM PER QQ-A-250/11
 REF DART SPEC M8081T6S
 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4753-1" AND B/N PER QSI 044 METHOD 6.7
 7) WEIGHT: 0.01 lbs

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A NEW ISSUE		AP	13.02.13
REV.	DESCRIPTION		BY DATE
DESIGN	AP	DART AEROSPACE USA, INC.	
DRAWN	AP	KENT, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4753	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		DOUBLER	NTS
DATE	13.02.13		

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RELEASED
 2013-03-25
 WJ

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